

Friday, 9/21/2007 1:18:31 PM
Klip Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SADDLE FITTING, FWD (OUTBOARD/INBOARD) |
| Job Number | : 34813 | | |
| Estimate Number | : 10531 | | |
| P.O. Number | : | Part Number | : D2572 |
| This Issue | : 9/21/2007 S.O. No. : | Drawing Number | : D2572 REV E |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 9/21/2007 Type : MACHINED PARTS | Drawing Revision | : E |
| Previous Run | : 34749 | Material | : |
| Written By | : | Due Date | : 10/18/2007 Qty: 8 Um: Each |
| Checked & Approved By | : <u>07.09.24</u> | | |
| Comment | : Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|-------------------------|
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5 |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: 631338

8F 07/10/25

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 28 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

JL / 28 07/10/25

⑧

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

J.L 07/10/28

⑧

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/10/28

⑧

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34813

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MR 07/10/28

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/10/29

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105008

BR 07-10-29

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

CE 07-10-29

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 432*

07/10/30

AS

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31 *AS*

Job Completion



U ST 432

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 34813 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|-------------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | DT8682 | .440 | .442 | .442 | .442 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | .500 | .502 | .502 | .501 | | |
| G | 0.257 | 0.262 | DT8683 | .258 | .258 | .257 | .257 | | |
| H | 0.375 | 0.380 | DT8684 | .375 | .375 | .375 | .375 | | |
| I | 0.490 | 0.510 | | .502 | .502 | .502 | .503 | | |
| J | 1.174 | 1.184 | | 1.180 | 1.180 | 1.180 | 1.180 | | |
| K | 0.558 | 0.578 | | .569 | .568 | .568 | .569 | | |
| L | 1.174 | 1.184 | | 1.180 | 1.180 | 1.180 | 1.180 | | |
| M | 1.490 | 1.500 | | 1.500 | 1.500 | 1.500 | 1.500 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | .126 | .122 | .124 | .122 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .251 | .248 | .251 | .250 | | |
| S | 0.115 | 0.135 | | .124 | .126 | .126 | .121 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .184 | .188 | | |
| U | 2.940 | 2.980 | | 2.962 | 2.962 | 2.962 | 2.963 | | |
| V | 0.230 | 0.250 | | .240 | .240 | .240 | .240 | | |
| W | 0.115 | 0.135 | | .124 | .124 | .125 | .123 | | |
| X | 0.307 | 0.312 | | .312 | .312 | .312 | .311 | | |
| Y | 0.760 | 0.765 | | .763 | .763 | .763 | .763 | | |
| Z | 0.352 | 0.372 | | .364 | .364 | .362 | .366 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .630 | .628 | .627 | .620 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .240 | .240 | .240 | .240 | | |
| AE | 1.375 | 1.395 | | 1.382 | 1.380 | 1.380 | 1.381 | | |
| AF | 0.115 | 0.135 | | .125 | .125 | .125 | .135 | | |
| AG | 0.240 | 0.280 | | .250 | .250 | .250 | .250 | | |
| AH | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.000 | 2.005 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|------------------------|------------------------|
| Measured by: JS | Audited by: JIL |
| Date: 07/10/25 | Date: 07/10/28 |

| | |
|------------------------|------------------------|
| Measured by: JS | Audited by: JIL |
| Date: 07/10/25 | Date: 07/10/28 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 34813 |
| Description: Saddle, Fwd Inboard | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|-------------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 16 | 17 | 18 | By | Date |
| A | 0.438 | 0.443 | DT8682 | .442 | .442 | .442 | .442 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.000 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | .500 | .503 | .503 | .505 | | |
| G | 0.257 | 0.262 | DT8683 | .257 | .257 | .257 | .257 | | |
| H | 0.375 | 0.380 | DT8684 | .375 | .375 | .375 | .375 | | |
| I | 0.490 | 0.510 | | .503 | .505 | .502 | .504 | | |
| J | 1.174 | 1.184 | | 1.170 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .570 | .572 | .569 | .572 | | |
| L | 1.174 | 1.184 | | 1.180 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.500 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | .121 | .121 | .127 | .126 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .250 | .249 | .250 | .248 | | |
| S | 0.115 | 0.135 | | .123 | .120 | .120 | .121 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 2.940 | 2.980 | | 2.962 | 2.962 | 2.962 | 2.962 | | |
| V | 0.230 | 0.250 | | .239 | .238 | .235 | .231 | | |
| W | 0.115 | 0.135 | | .125 | .125 | .123 | .123 | | |
| X | 0.307 | 0.312 | | .311 | .311 | .311 | .311 | | |
| Y | 0.760 | 0.765 | | .763 | .763 | .763 | .763 | | |
| Z | 0.352 | 0.372 | | .366 | .366 | .364 | .366 | | |
| AA | 0.470 | 0.530 | | .520 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .626 | .626 | .627 | .628 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .245 | .242 | .243 | .240 | | |
| AE | 1.375 | 1.395 | | 1.391 | 1.386 | 1.393 | 1.392 | | |
| AF | 0.115 | 0.135 | | .130 | .130 | .130 | .130 | | |
| AG | 0.240 | 0.280 | | .250 | .250 | .250 | .250 | | |
| AH | 0.240 | 0.260 | | .249 | .248 | .242 | .246 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.004 | 2.004 | 2.006 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | <i>JS</i> |
| Date: | 02/10/26 / 07/10/28 |

| | |
|-------------|-----------|
| Audited by: | <i>JS</i> |
| Date: | 07/10/28 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>JS</i> |

05.12.06

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